SPECIFICATIONS

Gauge	20
Chamber	3"
Action	Gas Operated
Magazine Capacity	4 (2 with plug)
Weight	6-½ pounds

STOCK DIMENSIONS

Field: 1½" x 2½" x 14"
Skeet: 1½" x 2¼" x 14"

Product Warranty

Ithaca products are warranted against defects in workmanship and materials for one year from purchase. Manufacturer's warranty obligations are limited to repair or replacement of defective parts in products returned to its or an authorized Warranty Repair Station and manufacturer assumes no liability for any incidental or consequential damages. Ithaca guns are designed, manufactured and proof-tested to specifications of factory loaded ammunition. Use of other than factory loaded ammunition invalidates this warranty. No warranties are authorized to be made other than those stated herein. This warranty is expressly in lieu of any other expressed or implied warranties, including any implied warranty of merchantability or fitness, and of any other obligation on the part of the manufacturer.

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ITHACA GUN COMPANY, INC.
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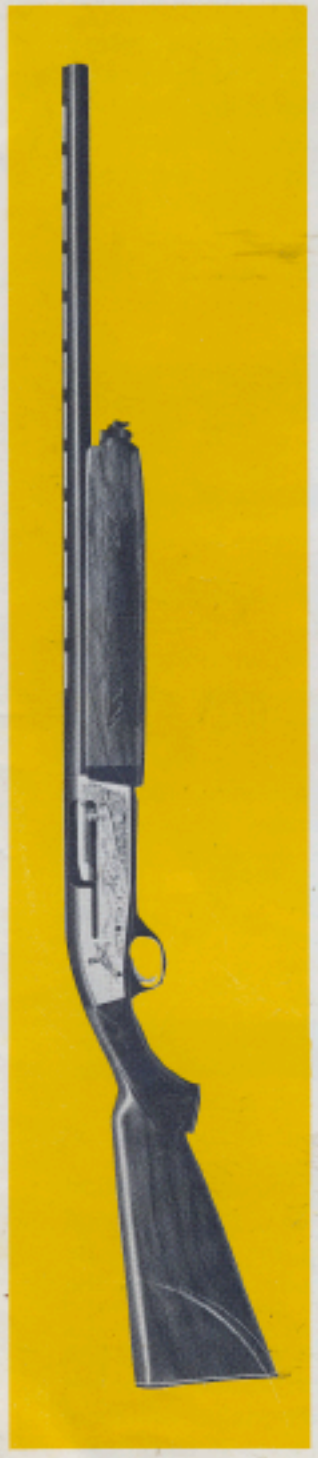

Ithaca - SKB
XL 300 and XL 900
Gas Semi - Automatic
20 Gauge

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ASSEMBLY

Your new Ithaca-SKB 20 ga. gas operated semi-automatic shotgun is packaged with the barrel removed from the action.
To prevent possible damage to your new gun, please follow the assembly steps outlined below.

1. Remove the magazine cap and slide the forend off the magazine tube.

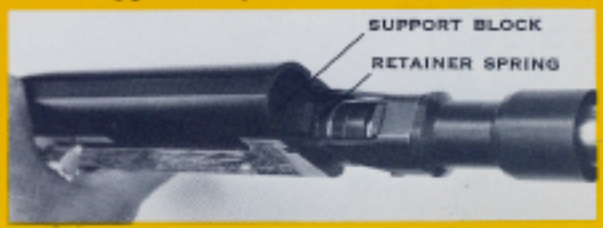
2. Open the action by pulling the charging handle to the rear until it stops. It will lock in this position.
   Using a clean soft cloth, wipe the magazine tube to remove the preservative oil.
   NOTE: Do not oil this tube except for long term storage!
   Use a good quality cleaning rod with a cloth patch to remove all traces of preservative oil from the bore.

3. With the bolt still in the open position slide the barrel ring over the magazine tube and barrel into the receiver. Be sure the barrel is fully seated in the receiver.
   Slide the forend along the magazine tube until fully seated (about ¾" of the forward end of the magazine will show

when forend is fully seated). Install the magazine cap and tighten finger tight.

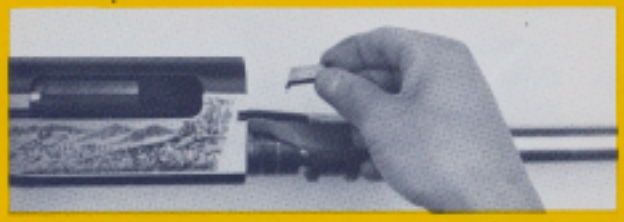
DISASSEMBLY AND CLEANING

4. Put the safety in the "ON" position (Red Band Hidden).
   Check chamber and magazine for shells.
   Remove magazine cap and forend.
   Open the action and remove the barrel forward off the magazine tube.
5. Holding the charging handle with one hand, depress the carrier release button and allow the bolt to go forward **slowly.**
   Push out the two trigger plate pins and pull forward and down to remove the trigger group.



6. At the forward end of the receiver is the support block and the support block retainer spring. Rotate this spring

counter clockwise until it clears the support block pin. Lift the support block up and forward.



7. A sharp pull straight out on the charging handle will release it from the bolt. Slide the gas sleeve and the action bar forward off the magazine tube. NOTE: Carbon buildup on the magazine tube may make removal of the gas sleeve difficult. If so, use 00 steel wool soaked in cleaning solvent to remove excess carbon from the magazine tube. Wipe dry with a clean cloth.

8. The action bar may be removed from the gas sleeve by lifting the rear to disengage the locking cams.

9. Clean all parts by washing with a good solvent and wipe dry with a soft cloth. Oil all friction points on trigger and bolt assemblies with a good light oil. **Do not** oil magazine tube or gas sleeve. Barrel may be cleaned with a proper

size patch and solvent. If bore becomes leaded, use a wire bore brush. Clean the barrel ring and the gas ports with a soft cloth and solvent. If there is heavy carbon buildup on this area use a soft wire brush or knife blade to gently scrape the carbon away. Be careful not to damage the gas ports or gas seals.

NOTE: Do not attempt to remove the gas selector switch.
Also, disassembly of the trigger group and gas selector switch should be done only by a qualified repair station.

PROPER POSITION OF LOADAMATIC SELECTOR

10. This Ithaca-SKB shotgun is equipped with a gas selector to allow you to fire all loads in the same barrel. To assure proper function the selector switch must be set as follows:

For all 2¾" and 3" MAGNUM ammunition align the letter "H" with the index point.

For all other loads align the letter "L" with the index point. A coin or the base rim of a fired shell may be used to position the selector switch. NOTE: Firing magnum loads on "L" setting will increase recoil and may damage your gun.

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Loading and Unloading

14. Make certain gun is empty. Put safety in on position by pushing button left to right until red disappears.

15. To load chamber, pull back charging handle until action remains open. Insert shell into loading port of receiver and slowly close action. **Note:** A round will feed from magazine to chamber when charging handle is pulled back by hand.

16. To load magazine, depress carrier latch button and push carrier plate down. Insert shell into magazine until it is held by the shell stop. Magazine capacity is four rounds (two with plug installed).

17. To unload magazine, depress carrier latch button and push carrier plate down. Holding shell stop with thumb, remove shells from magazine. To unload chamber, pull back charging handle. **Note:** All shells may be removed by pulling back charging handle and cycling shells from magazine to chamber.

NOTE: The stock and forend on the Model XL 900 Deluxe are finished with an exclusive highlight finishing process which is applied by hand and provides the outstanding appearance long associated only with the finest grained walnut. Refinishing should not be attempted. Severely marred stocks should be replaced by the factory.

Installation of 3-Shot Magazine Plug

(To comply with Federal Migratory Bird Regulations)

1. Remove magazine cap while holding barrel securely.
2. Insert the magazine plug directly into the center of magazine until the flat cap of the plug rests on the end of the magazine spring retainer.
3. Reassemble gun in regular manner.